

Date: Wednesday, 1/30/2008 7:50:12 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL PURGE CANISTER INSTALLATION
 Job Number : 37049
 Estimate Number : 12188
 P.O. Number :
 This Issue : 1/30/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D205706013
 First Issue : 1/1 Type : LARGE FAB ASSY Drawing Number : N/A
 Previous Run : 36746 Drawing Revision : N/A
 Written By :
 Checked & Approved By : 1/30/08 01 30
 Comment : Est Rev E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D KJ/JLM Material :
 Due Date : 2/15/2008 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D205-706-013CHG001

508/02/15

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D20014 Valve 1/4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
 1 D2001-4 Valve Assembly 32157

1/24/12 (2)

4.0 D3262041 Fuel Purge Canister



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
 1 D3262-041 Canister Assembly 36277

B

5.0 D32641 Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
 2 D3264-1 Bracket 34243

24 B35133 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 37049

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D329710121

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Hose Ass'y

Qty Part Number Description Batch

1 D3297-1-0121 Hose Assembly

B35135

CU

7.0

D329710130

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Hose Ass'y

Qty Part Number Description Batch

1 D3297-1-0130 Hose Assembly

B37075

(2x)

8/2/15 SD

8.0

D329730350

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Hose Ass'y

Qty Part Number Description Batch

1 D3297-3-0350 Hose Assembly

B37076

8/2/15 SD

9.0

D3298001

Tube Assembly 25"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit

Qty Part Number Description Batch

1 D3298-001 Tube Assembly

35136

CU

10.0

D3298009

Tube Assembly 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit

Qty Part Number Description Batch

1 D3298-009 Tube Assembly

35137

CU

11.0

D32991

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3299-1 Fitting

35138

CU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 37049

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D32993

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3299-3

Fitting 35139

13.0

D33011

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-1

Placard 23304

14.0

D33013

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-3

Placard 23305

15.0

D33021

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-1

Doubler 35129

16.0

D33023

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-3

Doubler B34045

17.0

AN35A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN3-5A

Bolt 19536

10/5/12 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 37049

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN8146D

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN814-6D

Plug

M17710

19.0

AN8156D

Union-M-Flare



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN815-6D

Union

M17654

20.0

AN8336D

Elbow, Bulkhead-M-Flare



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 AN833-6D

Elbow

M103691 2P M105578 4X

21.0

AN9246D

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN924-6D

Nut

M104374

22.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN960JD10

Washer

M105792 6X
M106167 10X

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

M104885

1/24/12 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:50:12 AM
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Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 37049

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN960JD916

Washer

24.0

AN960JD916

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN960JD916

Washer

M100857

25.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21042L3

Nut (or -3)

M106292

26.0

MS21919WDG9

Clamp



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 MS21919WDG9

Clamp

M103044 1K M104715 9K

27.0

MS21919WDG12

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

Qty Part Number

Description

Batch

1 MS21919WDG12

Clamp

M101925

28.0

MS21919WDG16

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

Qty Part Number

Description

Batch

2 MS21919WDG16

Clamp

M105578

29.0

MS2192042

CLAMP(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21920-42

Clamp

M18048 2K M107117 2K / 104/2/15 / 104/2/12 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 11 Date: 08/02/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:50:12 AM
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Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 37049

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

MS287786

Packing



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 MS28778-6

O-Ring

M104885 9x M105978 1x

31.0

MS3548911

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 MS35489-11

Grommet

M16 323 PC 8/2/12 (2)

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2 08/02/15 (2)

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD205-706-013

Location:

PPP Rev:

3 8/2/15 su 2x

34.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2 08/02/17

Job Completion



u 08/02/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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 Job Number : 37049
 Estimate Number : 12188
 P.O. Number : Part Number : D205706013
 This Issue : 1/30/2008 S.O. No. : Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : N/A
 Previous Run : 36746 Material :
 Written By : Due Date : 2/15/2008 Qty: 2 Um: Each
 Checked & Approved By : 08 01 30
 Comment : Est Rev: E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D205-706-013CHG001

08 01 31

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D20014 Valve 1/4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2001-4	Valve Assembly	

REFERENCE ONLY

4.0 D3262041 Fuel Purge Canister



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D3262-041	Canister Assembly	

5.0 D32641 Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3264-1	Bracket	